

Work Order ID 93142

November-14-12 3:06:23 PM

93142

to Rev A 8/31/15
~~PRIMARY ISSUE~~

Page 1

Item ID: D4743-1 Accept *N900040100* Setup Start *NS1*
Revision ID: PRELIM Stop *NS2*
Item Name: Speaker Grill
Start Date: 11/14/12 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 11/15/12 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4743	pa1 <u>Rev A</u>								
110		0.00							
110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>PA1</u> Prog Rev: <u>PA1</u> 2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

② 1812-11-14
② 1812-11-14

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Page 2

November-14-12 3:06:23 PM

Item ID: D4743-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Speaker Grill
 Start Date: 11/14/12 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 11/15/12 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 - inspect to PA1 Dug only 0.00 DAS 15 2-89 12/14/15 (x12)							
140 *140* Small Fab Small Fab	Memo C'sink holes as per dwg	0.00 0.00				124			12/11/18
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 10-11-15				12 12/11/15 Dug PA1			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Start Date: 11/14/12 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 11/15/12 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160						12	26	12-11-15	
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170						12X		12/11/15	
QC	Memo	0.00							
Quality Control									
180	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
180						12X		12/11/15	
Powdercoat	Memo	0.00							
Powder Coating	POWDER COAT: 3'-45								
	Start Time: 3200 F								
	Oven Temperature: 3200 F								
	Finish Time: 4-15								

M/12/1274

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Page 4

November-14-12 3:06:23 PM

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 Start Date: 11/14/12 Start Qty: 12.00 *12* Cust Item ID:
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control	 inspects to ps) dug only. 12/11/12 (+12)								
200	Identify as per dwg & Stock Location: _____	0.00							
200									
Packaging	Memo	0.00							
Packaging	ST 122								
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE

RELEASED

AUTH

DATE

16

9-8 to Rev A

ME 12-11-16

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Doc/Data <input type="checkbox"/>											
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Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

November-14-12 3:06:23 PM

Page 1

Work Order ID: 93142

Parent Item: D4743-1

Parent Item Name: Speaker Grill

Start Date: 11/14/12

Required Date: 11/15/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 12.11.14 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			110	sf	300.5843	0.195	2.4631579			

1812-11-14

Location

Loc Qty

Loc Code

MAT021

300.584316

117285

0.124316

119766

22.66

120096

84.4

123279

193.4

123279

(2)

NCR: Yes / No

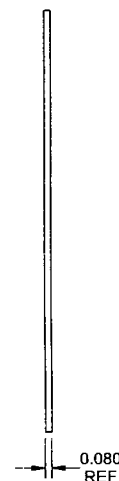
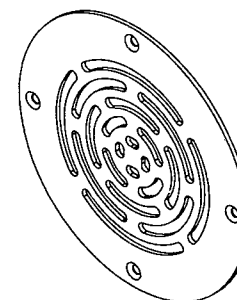
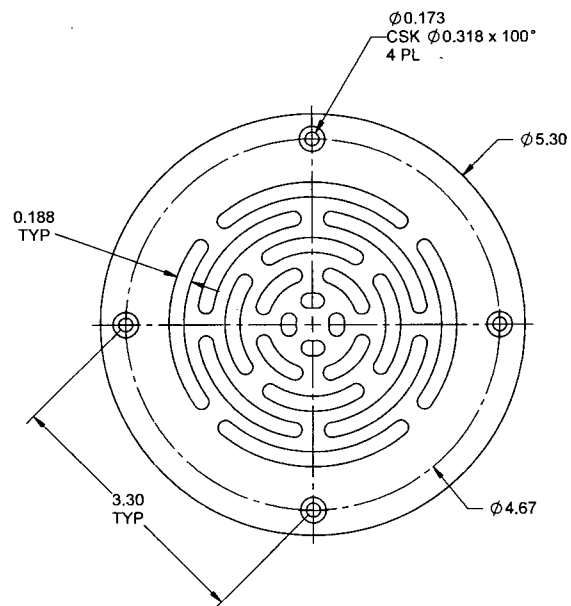
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



D4743-1 SPEAKER GRILL

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDING" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.13 lbs
- 8) CUT PART PER D4743-1 DXF.

wo 93142
REA.

PRELIMINARY ISSUE

12.11.13

PA1	NEW ISSUE	RF	12.11.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.13		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4743	REV. PA1
TITLE SPEAKER GRILL	SCALE NTS

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NCR: Yes / No

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Unapproved											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Receiving Report

Date: 12/10/10

Batch No: M/23279

Supplier: TITXGOSPEL/ANPA

Dart P/O: 18068

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒
 Shipment Complete: ^{DAS} Yes ☐ No ☒ N/A ☐
 QC6 Inspection: 19 12/10/11 N/A ☒
 Work Order: 83 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M606/T6	30-375X0.100	318	36	0	12	
M30451860		192	160	0	32	
M2024 TS3.0190		48	0	0	48	

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 12/10/10
 Date
 Received/Costing
 Initial [Signature]

Location _____

°Purchase Order Receipt Listing

Page 1 of 2

Wednesday, October 10, 2012 1:56:38 PM

All amounts are calculated in domestic currency.

All Vendors PO ID PO18068 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name VC-COP001 Thyssenkrupp Materials CA Ltd											
PO18068	1		M303B1.000X03.000 f		10/10/2012	10/10/2012	8.0000	\$51.32	0.0000	0	\$410.53
CAD	No		303 BAR 1" X 3' f		8.0000	DESJ02		\$410.53	0.0000	0	
			123279								
	2		M303H0.500 f		10/10/2012	10/10/2012	12.0000	\$2.85	0.0000	0	\$34.17
	No		303 HEX BAR .500 f		12.0000	DESJ02		\$34.17	0.0000	0	
			123279								
	3		M304S18GA sf		10/10/2012	10/10/2012	160.0000	\$3.44	0.0000	0	\$550.51
	No		304/316 .050 Sheet sf		192.0000	DESJ02		\$550.51	0.0000	0	
			123279								
	4		M6061T6B0.250X02. f		10/10/2012	10/10/2012	72.0000	\$1.19	0.0000	0	\$85.68
	No		6061-T6 Bar .250 X f		72.0000	DESJ02		\$85.68	0.0000	0	
			2.00								
			123279								
	5		M6061T6B0.250X06. f		10/10/2012	10/10/2012	36.0000	\$3.61	0.0000	0	\$129.99
	No		6061-T6 Bar .250 x f		36.0000	DESJ02		\$129.99	0.0000	0	
			6.00								
			123279								
	6		M6061T6B0.375X01. f		10/10/2012	10/10/2012	36.0000	\$0.95	0.0000	0	\$34.16
	No		6061T6 BAR .375 x f		48.0000	DESJ02		\$34.16	0.0000	0	
			1.00								
			123279								
	7		M6061T6B0.625X02. f		10/10/2012	10/10/2012	12.0000	\$3.92	0.0000	0	\$46.99
	No		6061-T6 Bar .625 x f		12.0000	DESJ02		\$46.99	0.0000	0	
			2.50								
			123279								

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name VC-COP001 Thyssenkrupp Materials CA Ltd											
PO18068	8		M6061T6B00750X00 f		10/10/2012	10/10/2012	100.0000	\$0.36	0.0000	0	\$36.11
CAD	No		125 6061-T6 Bar .750 x f		100.0000	DESJ02		\$36.11	0.0000	0	
			125 123279								
	9		M6061T6B1.000X02. f		10/10/2012	10/10/2012	24.0000	\$4.92	0.0000	0	\$117.98
	No		000 6061-T6 Bar 1.00 x f		24.0000	DESJ02		\$117.98	0.0000	0	
			2.00 123279								
	10		M6061T6B0.625X01. f		10/10/2012	10/10/2012	12.0000	\$2.24	0.0000	0	\$26.85
	No		500 6061-T6 Bar .625 x f		12.0000	DESJ02		\$26.85	0.0000	0	
			1.50 123279								
	11		M6061T6B0.187X04. f		10/10/2012	10/10/2012	60.0000	\$1.93	0.0000	0	\$115.95
	No		000 6061-T6 Bar .187 x f		60.0000	DESJ02		\$115.95	0.0000	0	
			4.00 123279								
	12		M6061T6B2.000X02. f		10/10/2012	10/10/2012	12.0000	\$11.75	0.0000	0	\$140.97
	No		250 6061-T6 Bar 2.00 x f		12.0000	DESJ02		\$140.97	0.0000	0	
			2.25 123279								
	13		M6061T6S.080 sf		10/10/2012	10/10/2012	288.0000	\$2.72	0.0000	0	\$783.98
	No		6061-T6 .080 Sheet sf		288.0000	DESJ02		\$783.98	0.0000	0	
			123279								
	14		M6061T6S.090 sf		10/10/2012	10/10/2012	96.0000	\$3.06	0.0000	0	\$293.99
	No		6061-T6 .090 Sheet sf		96.0000	DESJ02		\$293.99	0.0000	0	
			123279								
	15		M6061T6S.125 sf		10/10/2012	10/10/2012	144.0000	\$4.20	0.0000	0	\$604.72
	No		6061-T6 .125 Sheet sf		144.0000	DESJ02		\$604.72	0.0000	0	
			123279								
Total Received Quantity:											1,072.0000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											\$3,412.59
Total Balance Due Quantity:											44.0000

B I L L O F L A D I N G

No: PEC 789038

Ship From:
 THYSSENKRUPP MATERIALS NA
 2821 LANGSTAFF ROAD
 CONCORD, ONTARIO L4K 5C6
 Tel: 905 669 9444 Fax: 9057389033

Ship Date 09Oct12 at 13:18 From PFW
 Probill
 Via VIM TRANSFER
 FOB CONCORD
 Frt PREPAID
 Route 0- 0 Manifest
 Vhcle Trailer
 Slp STAN IVERS (905-532-1350)
 Sold To: (20115)
 DART AEROSPACE

Ship To: (1)
 DART AEROSPACE

B I L L O F L A D I N G

Heat Number	Tag No	Quantity	PCS	Wt LBS
201214546	111528	12 FT	1	14

11) Our Order PEC-497102- 11 Your PO # 18068

ALUMINUM FLAT BAR 6061-T6511

.187" x 4.00" X 240.0000"

Heat Number	Tag No
HK717 205	111487

MTR'S
 Quantity
 60 FT

PCS	Wt LBS
3	52

12) Our Order PEC-497102- 12 Your PO # 18068

ALUMINUM FLAT BAR 6061-T6511

2.00" x 2.50" X 144.0000"

Heat Number	Tag No
HK118 102	111529

MTR'S
 Quantity
 12 FT

PCS	Wt LBS
1	70

13) Our Order PEC-497102- 13 Your PO # 18068

ALUMINUM SHEET 6061 T6

.0810 Nom X 48.0000" X 144.0000"

Heat Number	Tag No
25872/01/00	111612

MTR'S
 Quantity
 288.00 SFT

PCS	Wt LBS
6	315

14) Our Order PEC-497102- 14 Your PO # 18068

ALUMINUM SHEET 6061 T6

.0910 Nom X 48.0000" X 144.0000"

Heat Number	Tag No
27049/01/00	111614

MTR'S
 Quantity
 96.00 SFT

PCS	Wt LBS
2	119

15) Our Order PEC-497102- 15 Your PO # 18068

ALUMINUM SHEET 6061 T6

.1250 Nom X 48.0000" X 144.0000"

Heat Number	Tag No
25875/01/00	111615

MTR'S
 Quantity
 144.00 SFT

PCS	Wt LBS
3	251

TOTAL:	Tags	PCS	LBS
	16	43	1437

Page: 3Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
 RAPPORTÉES IMMÉDIATEMENT.
 ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY.
 RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
 MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

18 OCT. 2012

DATE

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION
 TVQ/QST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

THYSSENKRUPP MATERIALS NA

DART AEROSPACE
ALUMINUM SHEET 6061 T6
.0810 Nom X 48.0000" X 144.0000"
PART NO.

PO/Rel 18068
We certify that this is a true copy of the report
furnished by the producer of the metal, or data
resulting from tests made in approved labs.

Certificate of Mill Test Results

BL PEC-789038-013 90a12
Signed by: _____ Pg 1/2



Abnahmeprüfzeugnis 3.1 (EN 10204) Inspection certificate – mill certificate

Nr.: 85289222 02 / 7

Rev. 0

Seite / page: 1 von / of 2

Datum / date: 2012 02 15

Zertifiziert nach / certified to ISO 9001, ISO/TS 16949, EN/AS 9100, ISO 14001, NADCAP

Auftraggeber / customer: ThyssenKrupp Materials NA 2821 Langstaff Rd CDN-L4K 5C6 CONCORD, ON Wareneimplänger / consignee: ThyssenKrupp Materials NA 2821 Langstaff Rd CDN-L4K 5C6 CONCORD, ON Endkunde, Bestell-Nr. / Your cust., ord. no.:	Bestell Nr. / order no.: PEC-236262 Datum / date: 2012 01 19 Auftragsbest. Nr. / order confirm. no.: 636296 Datum / date: 2012 01 20 Lieferschein Nr. / delivery note: 85289222 Datum / date: 2012 02 29 Akkreditiv Nr. / letter of credit no.:
--	--

Produkt/product Form / form: Sheet Werkstoff / material: 6061 Zustand / temper: T6 Dim. / dim: [inch]: 0,080x48,00x144,00 Kundenartikel-Nr / customer article no.:	Bedingungen/terms: Techn. Lieferbedingungen / techn. spec.: AMS-QQ-A-250/11, 08.1997 ASTM B 209 - 07 Material meets also the mech. properties of AMS 4027N, 07.2008, but not marked ANSI H35.2-2009 ASME SB 209, 2007 Sondervorschrift / special terms:
--	--

AB-Pos. ord.-item.	BNr/Los/Taillos Lot/No./Part	Guss Nr. cast no.	Werkstoff material	Kollo. packno.	Gewicht netto weight net	Stk. pcs.
02	25872/01/00	01/0047294/1	6061.1	6362960002	4029,982 lbs	77

Chemische Zusammensetzung / chemical composition: [%] Gewichtsanteile / weight proportion (OES)											
Guss Nr. / cast no.	AMAG designation	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	
01/0047294/1	6061.1										
	actual	0,65	0,48	0,23	0,11	0,91	0,18	0,01	0,04	0,06	

Zugversuch / Tensile test									
BNr/Los Lot/No.	Zustand temper	Richtung direction			Rm [ksi]	Rp0.2 [ksi]	A2" [%]		
25872/01	T6	LT			47,0	39,2	16		
25872/01	T6	LT			47,1	39,2	15		
25872/01	T6	LT			47,3	39,3	15		
25872/01	T6	LT			47,0	39,2	16		
25872/01	T6	LT			46,8	39,0	16		
25872/01	T6	LT			46,7	38,9	15		
25872/01	T6	LT			46,7	38,9	15		
25872/01	T6	LT			46,8	39,0	16		
25872/01	T6	LT			46,6	38,7	15		

Das
14
2-89 12/10/11

AMAG rolling GmbH, Postfach 32, A-5282 Ranshofen, Österreich – www.amag.at
AMAG rolling GmbH, P.O. Box 32, A-5282 Ranshofen, Austria – www.amag.at

THYSSENKRUPP MATERIALS NA

DART AEROSPACE

ALUMINUM SHEET 6061 T6
".0810 Nom X 48.0000" X 144.0000"
PART NO.

PO/Rel 18068

We certify that this is a true copy of the report
furnished by the producer of the metal, or data
resulting from tests made in approved labs.

Certificate of Mill Test Results

BL PEC-789038-013

90cr12

Signed by: _____

Pg 2/2



Abnahmeprüfzeugnis 3.1 (EN 10204) Inspection certificate – mill certificate

Zertifiziert nach / certified to ISO 9001, ISO/TS 16949, EN/AS 9100, ISO 14001, NADCAP

Nr.: 85289222 02 / 7

Rev. 0

Seite / page: 2 von / of 2

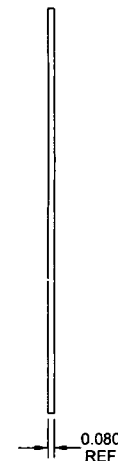
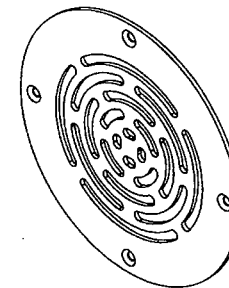
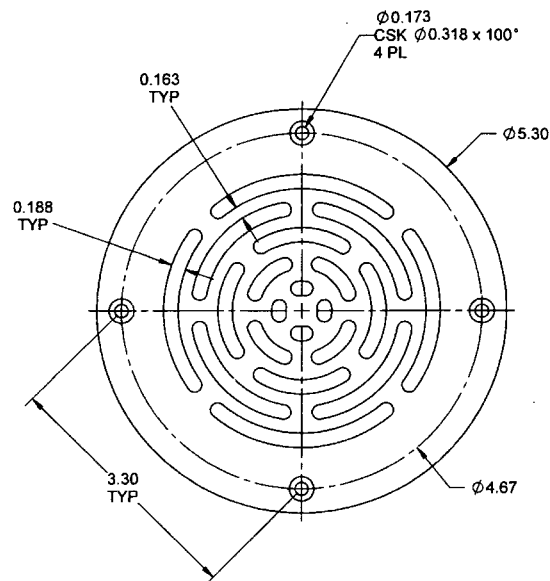
Datum / date: 2012 02 15

Es wird bestätigt, dass die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellung entspricht.
We hereby certify that the material described above has been tested and complies with the terms of the order
contract.

Werkssachverständiger / factory specialist	E-Mail / e-mail
Josef Klampl	j.klampl@amag.at

Herstellerland: Österreich / goods origin: The goods are of Austrian origin.
Maschinell erstellt - Gültig ohne Unterschrift / Automated - valid without being signed.

AMAG rolling GmbH, Postfach 32, A-5282 Ranshofen, Österreich – www.amag.at
AMAG rolling GmbH, P.O. Box 32, A-5282 Ranshofen, Austria – www.amag.at



D4743-1 SPEAKER GRILL

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.13 lbs
- 8) CUT PART PER D4743-1 REV A.DXF

RELEASED
2013-01-30

RELEASED
2013-01-30

A NEW ISSUE		RF	12.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4743	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPEAKER GRILL	NTS
DATE	12.11.30	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	